

Work Order ID 84187

84187

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May-07-12 11:05:21 AM

Item ID: D412-698-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cabin Door Roller, RH

Stop ***NS2***

Start Date: 07/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-698	Rev E
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

JB

(2) _____ 12-05-23
for MLS 12-5-22
(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2 _____ 12/05/22 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

2 _____ 12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-698-012

Accept

N9000040100

Setup Start ***NS1***

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Item Name: Cabin Door Roller, RH

Stop ***NS2***

Start Date: 07/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-012								
	Location: <u>62</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten notes and stamps:
 2
 6/5/38
 12/5/25
 12/5/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84187

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Parent Item: D412-698-012

D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from
Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141		Manufactured	No			110	Each	0.0000	3	6 ✓			
D3121-141									**	83457	JB	sm	
Bracket Assembly													
D3121-144		Manufactured	No			110	Each	3.0000	0	2 ✓			
D3121-144									**		JB		
Bracket Assembly													
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
				ST235				2					
				79311				2		79311	5		
				ST235A				1					
				75032				1					
D3137-043		Manufactured	No			110	Each	4.0000	0	2 ✓			
D3137-043									**		JB		
Bracket Assembly													
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
				ST235B				4					
				79734				4		79734	5		
D3183-044		Manufactured	No			110	Each	0.0000	0	2 ✓			
D3183-044									**	82689	JB	12/05/22	
Bracket Assembly													
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
				ST				-4					
				ST235B				4					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Parent Item: D412-698-012

D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 2.00

Required Qty: 2.00

D3199-1 Manufactured No

110

Each

31.0000

9 18 ✓

D3199-1

Bracket

**

JB

Location

Loc Qty

Loc Code

ST236

36

78618

2

82687

29

82687

S

ST236A

-5

D3202-1 Manufactured No

110

Each

15.0000

2 ✓

D3202-1

Cover

**

JB

12/05/22

Location

Loc Qty

Loc Code

ST241A

15

70294

2

82663

13

82663

S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01